

Work Order ID 76636

76636

Friday, November 18, 2011 10:18:23 AM

Item ID: K10112

Accept

N900040100

Revision ID:

Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/30/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code
--------------------------------	--------------------------	----------------------	---------	--------	--------------

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

Quality Control

130

Packaging

0.00

130

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP K10112
PPP D206-642-111
PPP D206-642-113
Location: _____
PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

Work Order ID 76636

Friday, November 18, 2011 10:18:23 AM

76636

Page 1

Item ID: K10112

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/30/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____

Date: 11/18/11

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9583

A

K10112

B

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP
FOR D206-642-111 CHG007
FOR D206-642-113 CHG002

0.00

0.00

K10112 CHG003

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

J. For MLT 11-12-8
(5)

11/18/11 sk

W/O:		WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Y
Resolution: _____ Disposition: _____ QA: N/C

NCR:		WORK ORDER NON-CONFORMANCE (N			
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sig D
			Initial Chief Eng	Action Description Chief Eng	

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:28 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F
11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14
AS PER DS19583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A <i>S/S Bolt</i> *AN3-41A*		Purchased	No			110	Each	1,655.000	8	40			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					st510			1655					
					119042			1655		40			
AN4-6A <i>S/S Bolt</i> *AN4-6A*		Purchased	No			110	Each	5,062.000	12	60			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST356			62					
					119127			62					
					ST516			5000		60			
					119017			5000					
AN4C5A <i>S/S Bolt</i> *AN4C5A*		Purchased	No			110	Each	489.0000	1				
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FP-B			49					
					112243			49					
					ST355			440					
					112243			340		5			
					119017			100					

S/S 11/12/18 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Friday, November 18, 2011 10:18:28 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

AN5-10A Purchased No

110 Each 872.0000 4

AN5-10A

**

20

Location

Loc Qty

Loc Code

ST337

872

116704

11

118191

59

119547

802

110

Each

1,599.000

4

AN5-11A

Purchased

No

AN5-11A

**

20

Location

Loc Qty

Loc Code

ST337

21

117313

2

118191

19

ST518

1578

119512

1578

110

Each

511.0000

2

AN6-44A

Purchased

No

AN6-44A

**

20

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110

Each

1.0000

1

D206-651-041

Manufactured

No

D206-651-041

**

10

206A/B GHW

Location

Loc Qty

Loc Code

FG125

1

74002

1

Friday, November 18, 2011 10:18:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D2652

Manufactured No

110

Each

743.0000

16

80

**

B73834

P

S ***D2652***

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

D2661-2

Manufactured No

110

Each

11.0000

2

10

**

B73843

11/12/18

(5)

S ***D2661-2***

S Saddle, RH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

6

10015

1

10016

1

10476

3

9913

1

ST435

5

74474

3

76517

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D2662-2

Manufactured No

110

Each

29.0000

2

10

7x

D2662-2

Saddle, RH In 206

**

B76794

sp B76798 3t 11/12/13

Location

Loc Qty

Loc Code

Mezz

2

11028

4

9042

3

9043

2

ST429

5

73852

2

76519

3

ST435

15

73853

15

D2712

Manufactured No

110

Each

2,551.000

10

50

D2712

Set Screw

**

50

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

D2884

Manufactured No

110

Each

100.0000

2

10

D2884

Saddle Spacer

**

10 11/12/13

50

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured No

110

Each

126.0000

2

10

**

D2885

Saddle, Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

D3413-1

Manufactured No

110

Each

94.0000

1

**

D3413-1

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

8,753.000

8

**

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

MS21042L4

Purchased

No

110

Each

11,450.00

12

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

Friday, November 18, 2011 10:18:29 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L6

Purchased

No

110

Each

1,484.000

2

**

10

MS21042L 6

S Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

10

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

**

11/12/8

SD

NAS1149C0463R

S Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

**

40

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

**

120

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

Friday, November 18, 2011 10:18:29 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:18:29 AM

Work Order ID: 76636

76636

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/18/2011

Required Date: 11/30/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8

**

40

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

40

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

**

20
11/12/10 SH/SD

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-2	2	2	2
5	D2662-2	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	K10112	SHEET 1 OF 1
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	